



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 196293



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/11/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 7/12/19

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VER:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VER:FJFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		7/12/19	0.00	0.65	Skidtubes - Bend		<i>ML</i>
120	Skidtubes - 2 - B4B	1 pcs		7/12/19	0.00	2.89	Skidtubes - 1 - B4B		
							Skidtubes - 2 - B4B		
							Skidtubes - 3 - B4B		
							Skidtubes - 4 - B4B		<i>TF</i>
							Skidtubes - 5 - B4B		
							Skidtubes - 6 - B4B		
							Skidtubes - 7 - B4B		
130	QC 5	1 pcs		7/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		<i>BE</i>
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
140	Skidtubes - 3 - B4B	1 pcs		7/12/19	0.00	2.89	Skidtubes - 1 - B4B		



Container No: S199560



Part: D205-634-041

Job No: 196293

Serial No/Batch: S199560

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96 - 88 Issue 2, FAA STC SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

S199560

150 QC 10	1 pcs	7/12/19	0.00 0.00	Skidtubes - 3 - B4B	TF BE
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
160 QC 5	1 pcs	7/12/19	0.00 0.00	QC 10 - 18	DAS AUG 08 2019 50 9-89
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	7/12/19	0.00 0.00	QC 5 - 10	DAS AUG 08 2019 58 9-89
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS AUG 08 2019 58 9-89
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS AUG 08 2019 58 9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	AUG 09 2019
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 -	

			B4B		
			Handfinish - 1 - 22 - B4B		
180 Powdercoat - 1 White GI(A)-B4B	1 pcs	7/12/19	0.00 0.34	Powdercoat - 1 - B4B	BL 19-8-14
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
190 QC 3	1 pcs	7/12/19	0.00 0.00	QC 3 - 10	HL 19-8-14
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
200 Handfinish - 4-1-Assembly-B4B	1 pcs	7/12/19	0.00 1.00	Handfinish - 4 - 1 - B4B	HL 19-8-21
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
210 QC 5	1 pcs	7/12/19	0.00 0.00	QC 5 - 10	DAS 81 9-89 AUG 20 2019
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
					Plex 6/11/19 11:05 AM Dart.lajeunesse.marie

DAS
15
9-89

					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
220	Packaging 3-1 - Stock - B4B	1	7/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
225	DC - 1 - B4B	1	7/12/19	0.00 0.00	DC - 1 - B4B	
	pcs				DC - 2 - B4B	
230	QC 21 - FG	1	7/12/19	0.00 0.00	QC 21 - FG - 21	
	pcs				QC 21 - FG - 70	
					QC 21 - FG - 53	

Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
 Descriptions: batch# In aft end of tube

120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 5-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 11:25 OVEN TEMPERATURE: 375°

FINISH TIME: 11:40

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 _____ Sikaflex expire date: _____ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 _____ Sikaflex expire date: _____ 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: _____

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	5198058
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	554302
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5198021
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5149158-1
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5192134
D2594-1	Plug 5189025(x13)	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5196148(x7)
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5173297
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5194524
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196397
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5196227
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	* 5201529
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	* 5201652
NAS1149C0332R	Washer	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5198136
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178376

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	5	0
140-Skidtubes - 3 - B4B	D2576-3	1	43	0
	D4202-1	20	769	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	764	0
	AN3-5A	2	176	0
	AN3C4A	50	790	0
	D2594-1	16	186	0
	D2594-3	16	331	0
	D2855	1	47	0
	D3564-11	1	13	0
	D3564-13	1	8	0
	D3564-5	1	9	0
	D3564-9	1	11	0
	NAS1149C0332R	50	2,746	0
	NAS1149D0332J	2	3,280	0

Part Specifications

Specifications could not be found.

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ITEM	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X				D2880-041	SKIDTUBE ASSEMBLY
2		X			D2880-045	SKIDTUBE ASSEMBLY
3			X		D2880-047	SKIDTUBE ASSEMBLY
4				X	D2880-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2880-1-190	EXTRUSION
21			18	18	D2870	BURNING
22	1	1	1	1	D2875-3	STEP
23			4		D2878	SPACER
24	18	18	8	8	D2884-1	PLUG
25	16	16	8	8	D2884-3	O-RING
26	1	1	1	1	D2886	205 WEB
27	1	1	1	1	D2885	AFT CAP
28	1	1	1	1	D2884-5	WEARSHOE
29	1	1	1	1	D2884-6	WEARSHOE
30	1	1	1	1	D2884-11	WEARSHOE
31	1	1	1	1	D2884-13	WEARSHOE
32	20	20	24	24	D4302-1	SPACER
33			1	1	D4406-041	WEARPLATE ASSEMBLY
34			1	1	D4406-043	WEARPLATE ASSEMBLY
35			1	1	D5051-1	FWD WEARPLATE
36			1	1	D5051-3	AFT WEARPLATE
60	60	60			AL57-1032-130 or AK57-1032-130 or AK54-1032-130 or AEL5-1032-130	INSERT
81	50	50			AN3CA4	BOLT
82	2	2	2	2	AN3-5A	BOLT
83			8	8	AN4-48A	BOLT
84	60	60			NA5114600352R	WASHER (AN600C10L)
85	2	2	2	2	NA5114600352J	WASHER (AN600J10L)
86			8	8	M521042-4	NUT (OR M521042-4)

- GENERAL NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION PER DART Q81 Q84.1 PRIOR TO INSERTING D2880 WEB
POWDER COAT (541407449) GLOSS WHITE (REF 43.5.1) PER DART Q81 Q84.3
POWDER COAT (448) GREEN SMOOTH (REF 43.5.6) PER DART Q81 Q84.3
BLACK ANTI-ROD PAINT AS INDICATED PER DART Q81 Q84.4.
 - 3) TOLERANCES ARE PER DART Q81 Q84 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX.
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: D2880-041 = 33.7 lbs
D2880-045 = 45.1 lbs
D2880-047 = 32.0 lbs
D2880-049 = 32.0 lbs
 - 8) WELDING PER DART Q81 Q84.
 - 9) INSERT D2880 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO
OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART Q81 Q84.5 BEFORE
BENDING. ENSURE HOLES LINE-UP.
 - 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND
ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS
ALLOWABLE IN THE BENT PORTION OF THE TUBE.
 - 11) USE DART DRILL TEMPLATE DT8217 & DT8697 ONLY FOR D2880-041-045 TO LOCATE AND DRILL
20.287 HOLES FOR WEARSHOE INSERTS. INSTALL AL57-1032-130 PER SECTIONS B-B AND F-F (80
PLACES) AFTER FINISH. INSTALL AN3CA4 BOLTS AND NA5114600352R WASHERS WITH
SIKAFLEX-241-281.
 - 12) INSERT D2884-1 PLUG ON D2884-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE) AFTER
FINISH (8 PLACES FOR D2880-041-045 AND 8 PLACES FOR D2880-047-049)
 - 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2880 AFT CAP TO PREVENT INTERFERENCE WITH
THE SPACER AT THIS LOCATION

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 46293
190611

REV.	DESCRIPTION	DATE
H	SHEET : PL DELETE D2880-1-24-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	17.06.09
G	ADDED -048 -047 WEIGHT UPDATED PER D81 9000	14.04.08
F	INCORPORATE DES D2880-E-1 PER PART2-218	13.06.20
E	ADD D2880-047 (2N C4-7) AND D2880-7 (2N E5-5) INCLUDED DES D2880-0-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8697 WAS TD2877-205 (2N C4-1)	11.06.21
D	CHANGE TO 83 WEARSHOE AND GASKETS,	07.04.06
C	INCLUDE DES 9124/ 9185	06.06.28
B	REDRAWN, INCLUDED DES 9004/ 6097	06.12.02
A	AS MANUFACTURED	04.03.16
	NEW ISSUE	04.03.16
DESIGN	DS	DATE
DRAWN	SAD	
CHECKED	REV. H	
MFEL APPR.	D2880	SHEET 1 OF 9
APPROVED	TITLE	SCALE
DE APPR.	205 SKIDTUBE ASSEMBLY	N/A
DATE	17.06.09	

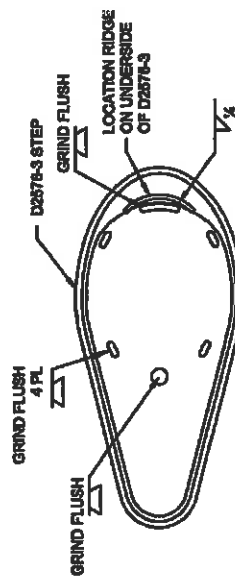
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HAINESBURY, ONTARIO, CANADA

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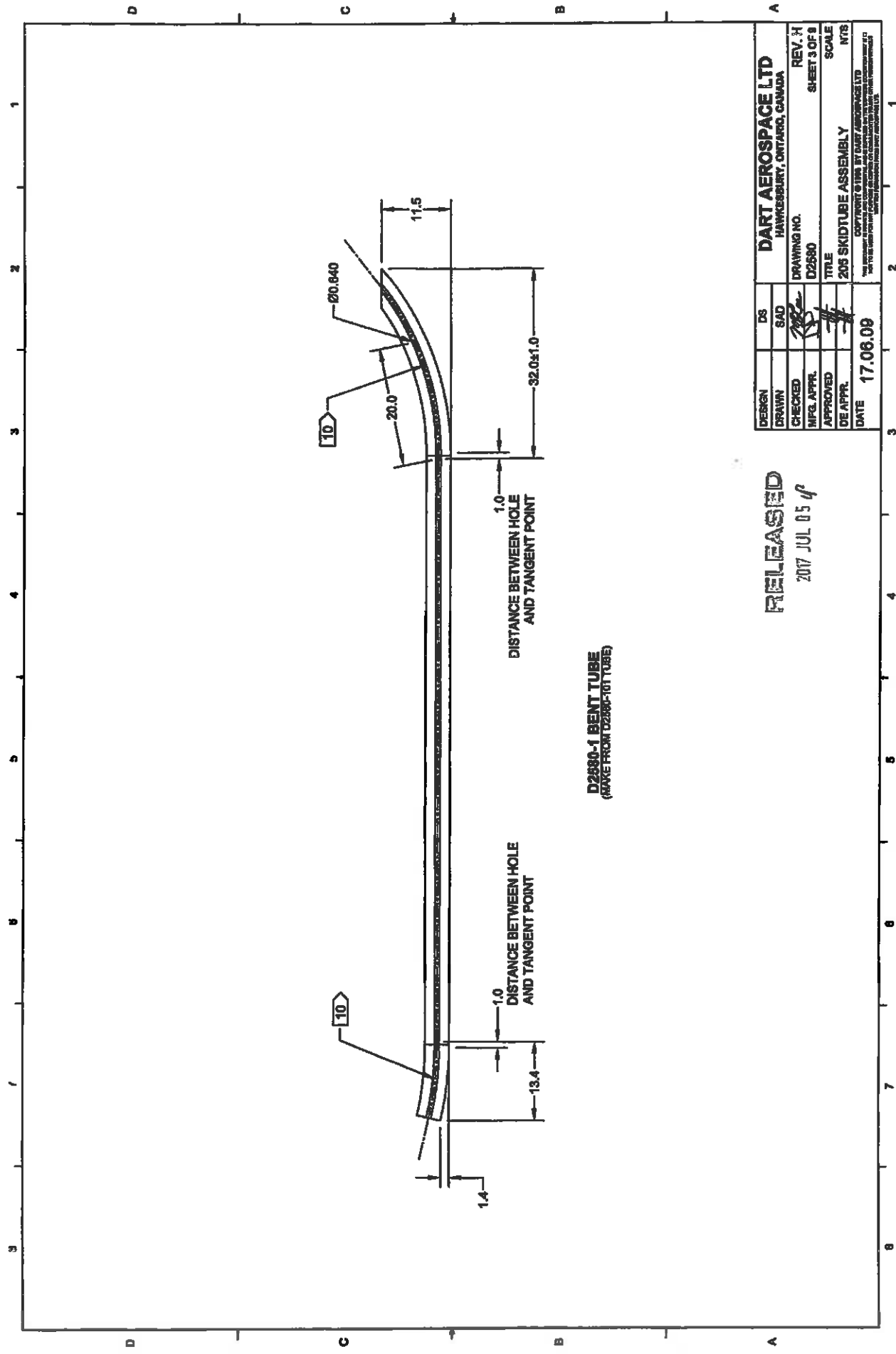
SECTION B-B
SCALE 6X



DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	
CHECKED	<i>[Signature]</i>	
MFG. APPR.	<i>[Signature]</i>	
APPROVED	<i>[Signature]</i>	
DATE	17.06.09	DRAWING NO. D2580 REV. H SHEET 2 OF 9 TITLE 206 SKIDTUBE ASSEMBLY SCALE NTS DESIGNED BY DART AEROSPACE LTD CHECKED BY DART AEROSPACE LTD MFG. APPR. BY DART AEROSPACE LTD APPROVED BY DART AEROSPACE LTD

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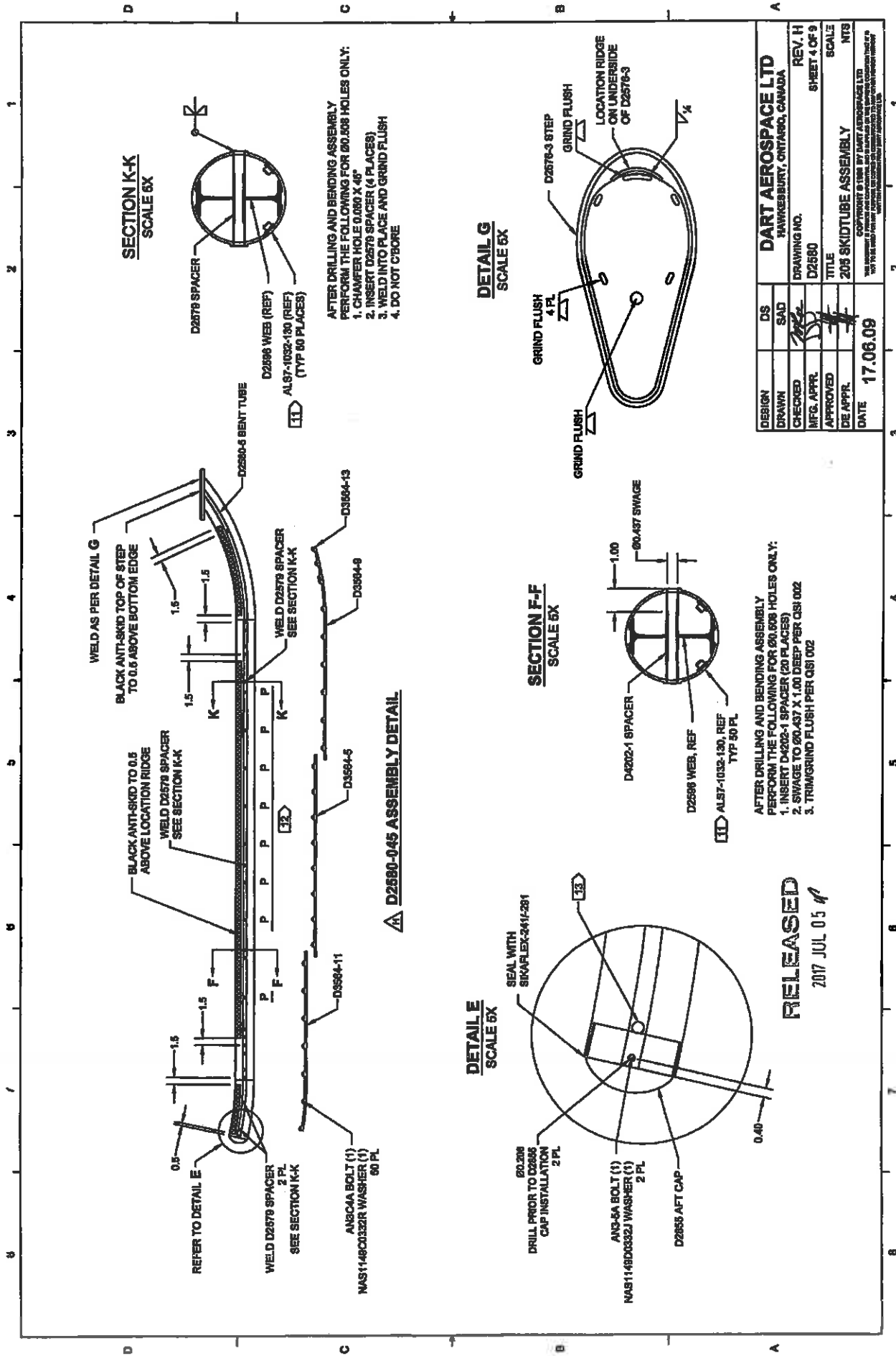
2017 JUL 05



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2017 JUL 05 4⁰

DESIGN	D8	DART AEROSPACE LTD
DRAWN	SAD	HAWKSBURY, ONTARIO, CANADA
CHECKED	WBC	DRAWING NO.
MFG. APPL.	WBC	D2580
APPROVED	WBC	TITLE
DATE	17.06.09	205 SKIDTUBE ASSEMBLY
		SCALE
		NTS

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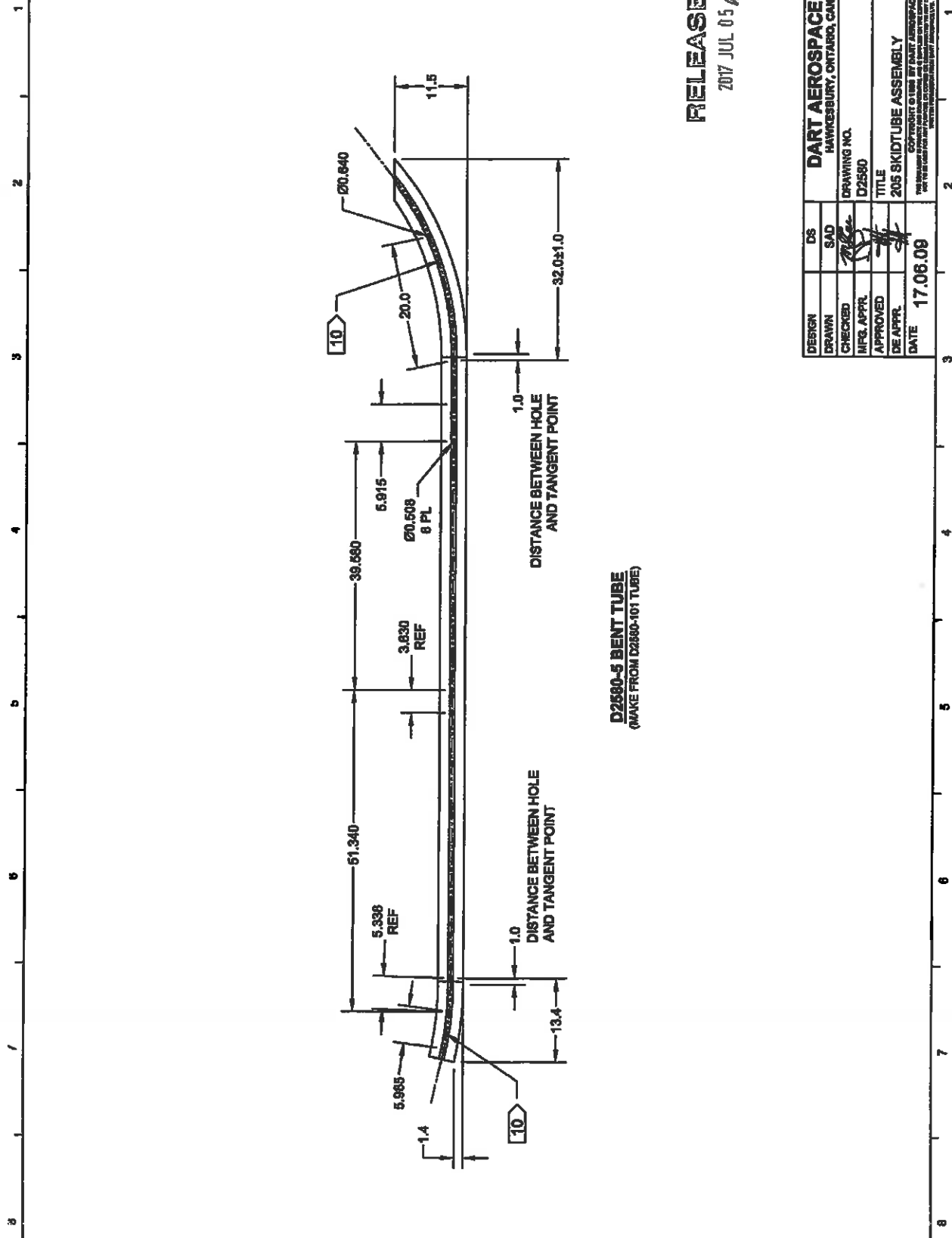


△ D2580-045 ASSEMBLY DETAIL

DESIGN	DS	SAD	DART AEROSPACE LTD
DRAWN			HAWKSBURY, ONTARIO, CANADA
CHECKED			DRAWING NO. REV. H
MFG. APPR.			D2580 SHEET 4 OF 9
APPROVED			TITLE SCALE
DE APPR.			208 SKIDTUBE ASSEMBLY NTS
DATE	17.06.09		

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 60.608 HOLES ONLY:
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO 90.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

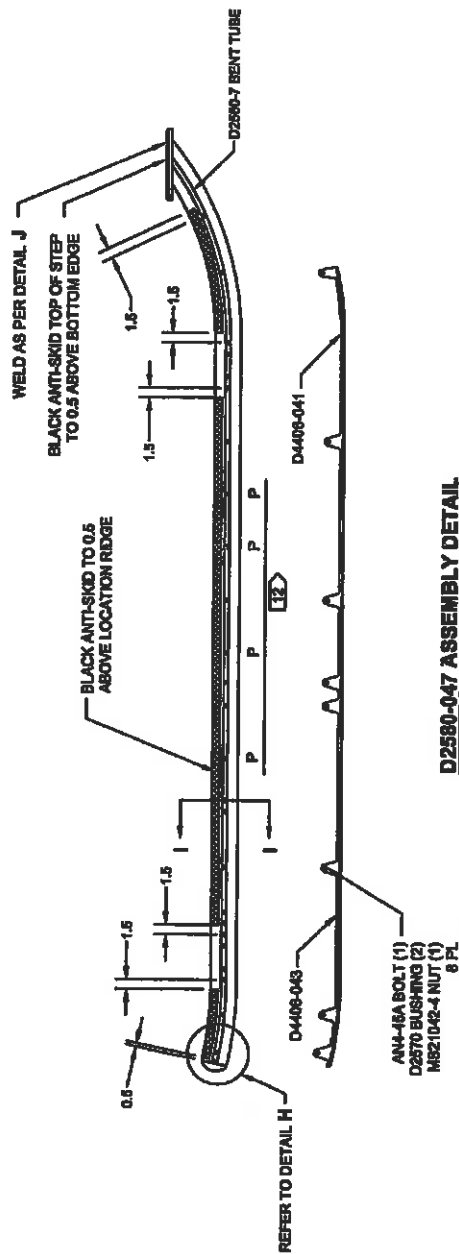
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2017 JUL 05



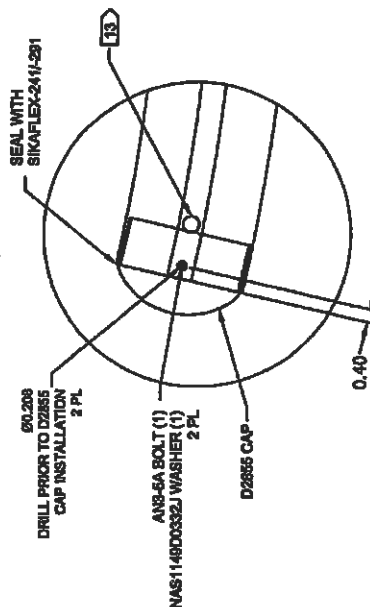
D2580-5 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO. D2580
MFG. APPR.	<i>[Signature]</i>	REV. H
APPROVED	<i>[Signature]</i>	SHEET 5 OF 8
DE APPR.	<i>[Signature]</i>	SCALE
DATE	17.08.09	TITLE
		205 SKIDTUBE ASSEMBLY
		NTS
		CONFIDENTIAL TO DART AEROSPACE LTD
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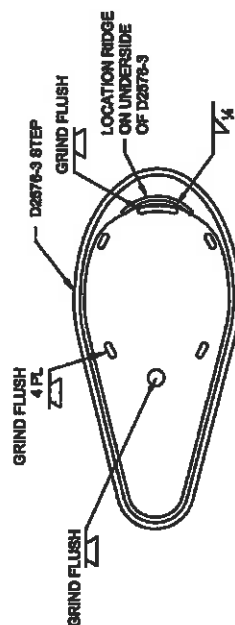
DETAIL H
SCALE 5X



SECTION H
SCALE 5X



DETAIL J
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 60.508 HOLES ONLY:

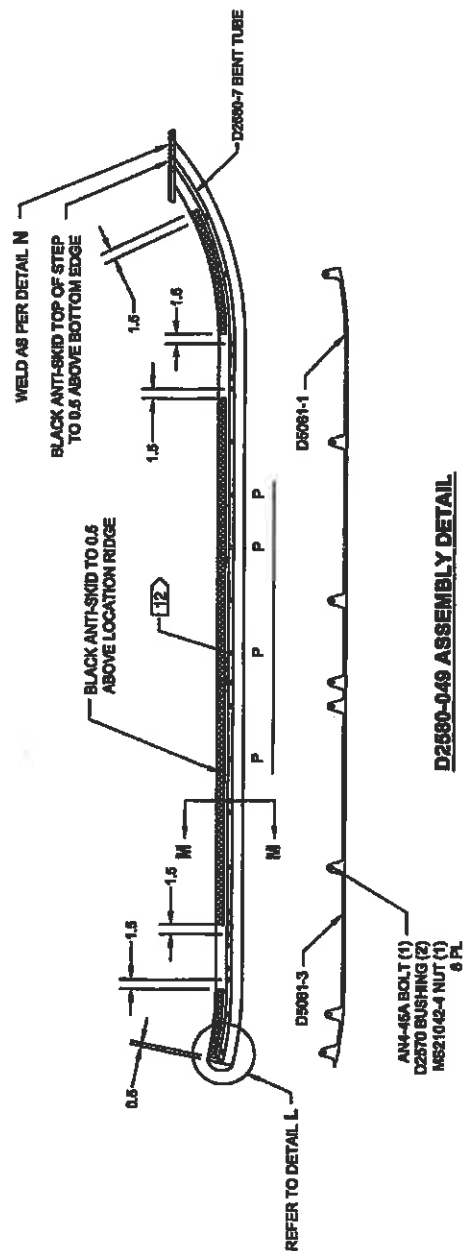
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO 60.437 X 1.00 DEEP PER QSI 002
3. TRIM/GRIND FLUSH PER QSI 002

DESIGN	DS	DART AEROSPACE LTD
DRAWN	SAD	HAMMERSBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2580
INFO. APPR.		REV. H
APPROVED		SHEET 8 OF 9
DATE		17.06.09
		SCALE
		205 SKIDTUBE ASSEMBLY
		NTS

RELEASED

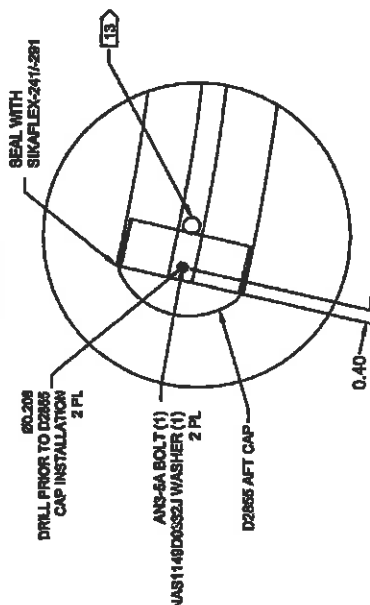
2017 JUL 05 40

1 2 3 4 5 6 7 8

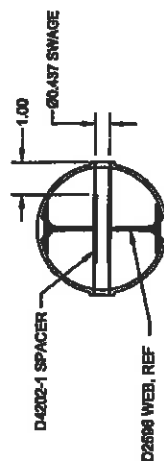


D2580-049 ASSEMBLY DETAIL

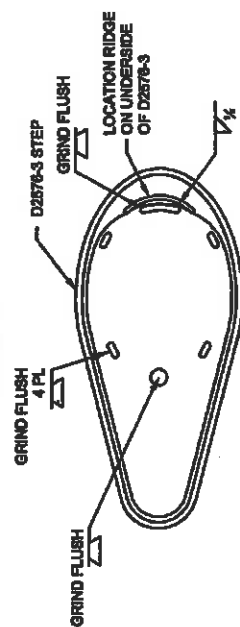
**DETAIL L
SCALE 5X**



**SECTION M-M
SCALE 5X**



**DETAIL N
SCALE 5X**



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. INSERT D4202-1 SPACER (2 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER CSI 002
3. TRIM GRIND FLUSH PER CSI 002

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2017 JUL 05

DESIGN	DS	DART AEROSPACE LTD	REV. H
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	SHEET 7 OF 9
CHECKED		DRAWING NO. D2580	SCALE
MFG. APPR.		TITLE	205 SKIDTUBE ASSEMBLY
APPROVED		DATE	17.06.09
DE APPR.			

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1 2 3 4 5 6 7 8

2017 JUL 05 *af*

DESIGN	DS	DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 8 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206 SKIDTUBE ASSEMBLY	NTS
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2017 JUL 05

DESIGN	D8	DART AEROSPACE LTD HANKS BURY, ONTARIO, CANADA	
DRAWN	SAD	DRAWING NO.	REV. H SHEET 9 OF 9
CHECKED	<i>MS</i>	D2580	SCALE
APPROVED	<i>MS</i>	TITLE	N78
DATE	17.06.09	205 COT TUBE ASSEMBLY	205 COT TUBE ASSEMBLY LTD
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details: _____					
Completed By		Lead hand / Supervisor			
QC / QA Coordinator					